



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

③

D212-664-201TRN
Job Sheet 195551



Part No: D212-664-201TRN

Job Qty: 1 pcs

Part Name: Crosstube Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/27/19

Job Tracking No:

Due Date: 6/8/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D212-664-241 REV E IPP Rev:A 08-03-06 new issue DD verified by:ec IPP Rev B 08.04.02 Removed polish
EC verified DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Mori Seiki TL-40 - 1	1 pcs	6/8/19	6/8/19	0.00	1.33	Mori Seiki TL-40 - 1			662019/07/30
110	QC 2	1 pcs	6/8/19	6/8/19	0.00	0.00	QC 2 - 1			9-89
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
							QC 2 - 8			
							QC 2 - 66			
							QC 2 - 64			

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					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120	Mori Seiki TL-40 - 1 - B4B	1 pcs	6/8/19	0.00 1.33	Mori Seiki TL-40 - 1 - B4B	DAS 662019-07-31 9-89
130	QC 2	1 pcs	6/8/19	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	DAS
					QC 2 - 66	662019-07-31
					QC 2 - 64	9-89
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
140	QC 8	1 pcs	6/8/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	

				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
145	Crosstubes - 2 - B4B	1 pcs	6/8/19	0.00 0.25	Crosstubes - 1 - B4B
					Crosstubes - 2 - B4B
					Crosstubes - 3 - B4B
					Crosstubes - 4 - B4B
150	Crosstubes - Bend - 2 - B4B	1 pcs	6/8/19	0.00 0.25	Crosstubes - Bend - B4B 1-3
160	QC 7	1 pcs	6/8/19	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
					QC 7 - 40
					QC 7 - 24
					QC 7 - 43
170	Packaging 3-1 - Stock - B4B	1 pcs	6/8/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B

				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	BIS 8/20/2019
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	1 pcs	6/8/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	53

Part Op 100 - Mori Seiki TL-40 (Mori Seiki CNC Lathe Large) 1-Fill tube with sand & install plugs DT8534 on both ends as per Descriptions: Folio FA114 2-Turn first side as per Folio FA114

110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - Mori Seiki TL-40 (Mori Seiki CNC Lathe Large) 1-Turn second side as per Folio FA114

130 - (QC2- Inspect parts off machine FAI/FAIB)

140 - (QC8- Inspect parts - second check)

145 - (Crosstubes) GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

150 - Crosstubes) 1- handfinish X-TUBE INSIDE AND OUT

160 - (QC7-Inspect Chemical Conversion Coat)

170 - (Identify as per dwg & Stock Location: _____) Identify and stock in kanban rack Location: _____

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6006-129	Crosstube Material	1 pcs (1 ea)	100-Mori Seiki TL-40 - 1	F123967

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Mori Seiki TL-40 - 1	D6006-129	1	53	0

Part Specifications

Specifications could not be found.

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Container No: S201484



Part: D212-664-201TRN

Job No: 195551

Serial No/Batch: S201484

Revision: E

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/30/19

③

DART AEROSPACE LTD	Work Order:	195557
Description: Crosstube Assembly (205/212 High Aft)	Part Number:	D212-664-241
Inspection Dwg: D212-664-241 Rev: E		Page 1 of 2

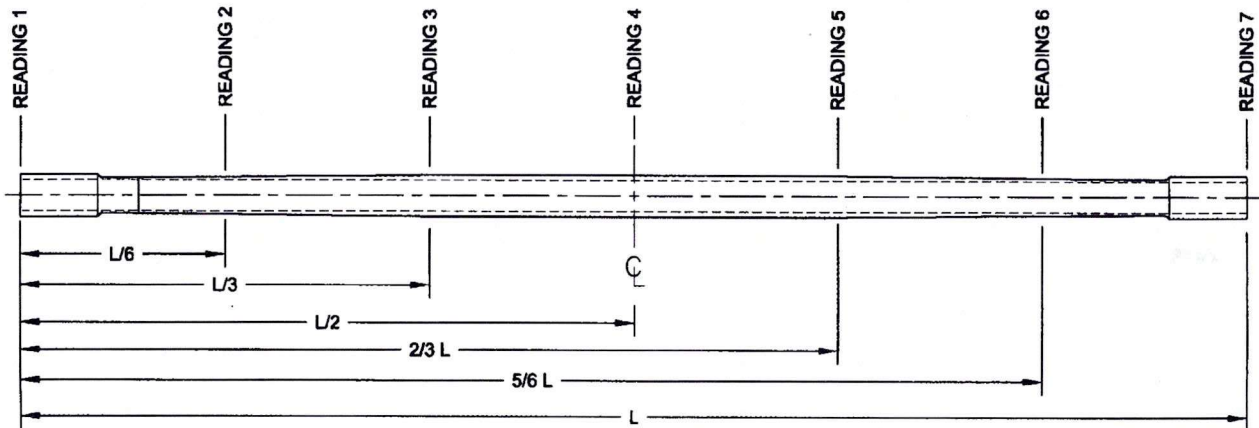
FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	.199	✓		CNC-08	
	R0.063	+/-0.010	.063	✓		RG	
	2.990	+0.005/-0.000	2.995	✓		CNC-04	
	5.237	+/-0.030	5.238	✓		CNC-08	
	2.600	+0.005/-0.000	2.605	✓		CNC-04	
	2.686	+0.005/-0.000	2.691	✓			
	2.770	+0.005/-0.000	2.775	✓			
	2.854	+0.005/-0.000	2.859	✓			
	2.938	+0.005/-0.000	2.943	✓			
	3.021	+0.005/-0.000	3.024	✓		CNC-05	
	3.133	+0.005/-0.000	3.138	✓		"	
	3.179	+0.005/-0.000	3.184	✓		"	
SIDE B	0.200	+/-0.010	.206	✓		CNC-08	
	R0.063	+/-0.010	.063	✓		RG	
	2.990	+0.005/-0.000	2.994	✓		CNC-04	
	5.237	+/-0.030	5.241	✓		CNC-08	
	2.600	+0.005/-0.000	2.605	✓		CNC-04	
	2.686	+0.005/-0.000	2.691	✓			
	2.770	+0.005/-0.000	2.775	✓			
	2.854	+0.005/-0.000	2.859	✓			
	2.938	+0.005/-0.000	2.941	✓			
	3.021	+0.005/-0.000	3.025	✓		CNC-05	
	3.133	+0.005/-0.000	3.138	✓		"	
	3.179	+0.005/-0.000	3.184	✓		"	
	124.362	+/-0.020	124.36	✓		tape	

③

DART AEROSPACE LTD		Work Order: 19555
Description: Crosstube Assembly (205/212 High Aft)		Part Number: D212-664-241
Inspection Dwg: D212-664-241 Rev: E		Page 2 of 2

WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	.433	.421	.364	.370	.069	0.062"
READING 2 L= 20.73	.361	.331	.270	.290	.091	
READING 3 L= 41.45	.523	.503	.454	.469	.069	
READING 4 L= 62.18	.561	.548	.512	.519	.049	
READING 5 L= 82.91	.509	.501	.470	.474	.039	
READING 6 L= 103.64	.336	.323	.293	.303	.043	
READING 7 L= 124.36	.421	.420	.374	.373	.048	

Dwg Δ
 0.385 - 0.021
 0.306 - 0.036
 0.474 - 0.020

Mean Ecc
 +0.012 -0.021
 +0.007 -0.036
 +0.013 -0.020

Acceptable per D6006 Rev. A
 4/12/31

Calibration Result

Actual Block Thickness: 200-500
 SITESCAN 250 Measured Thickness: 200-500

Measured by: 66 9-89	Audited by:	Preliminary Approval:
Date: 2019-07-31	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	
C	07.05.08	Dwg Rev. updated	KJ/JLM	
D	10.08.03	Dimension 124.362 was 124.36	KJ	
E	12.06.04	Wall thickness form added	KJ	
F	15.03.03	Dwg Rev updated	KJ	

Item	Qty -241	Qty -241B	Part Number	Description
1	X		D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
2		X	D212-664-241B	CROSSTUBE ASSEMBLY (214 HIGH AFT)
3	1	1	D6006-129	CROSSTUBE
4	2		D2940-1	SUPPORT
5	4	4	D3595-063-530	RUBBER CUSHION
6		2	D5018-1	SUPPORT
7	4	4	MS21920-28	CLAMP (OR MS21920-30)
8	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6006-129
FINISHED LENGTH = 124.362±0.020
- FINISH: a) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
b) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
c) MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C6-2 / C6-3, HATCHED AREA)
d) PAINT OUTSIDE PER DART QSI 005 4.2
e) REMOVE MASKING AND APPLY MATTE CLEAR COAT
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: D212-664-241/-241B = 44.2 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

MACHINING

- RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.

BENDING

- BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 7.2% (BASED ON O.D.) IN LOWER HALF OF R35.5 BEND AND 6% (BASED ON O.D.) ON REMAINING TUBE.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.

ASSEMBLY

- INSTALL D2940-1 / D5018-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE ON TOP SIDE OF CROSSTUBE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

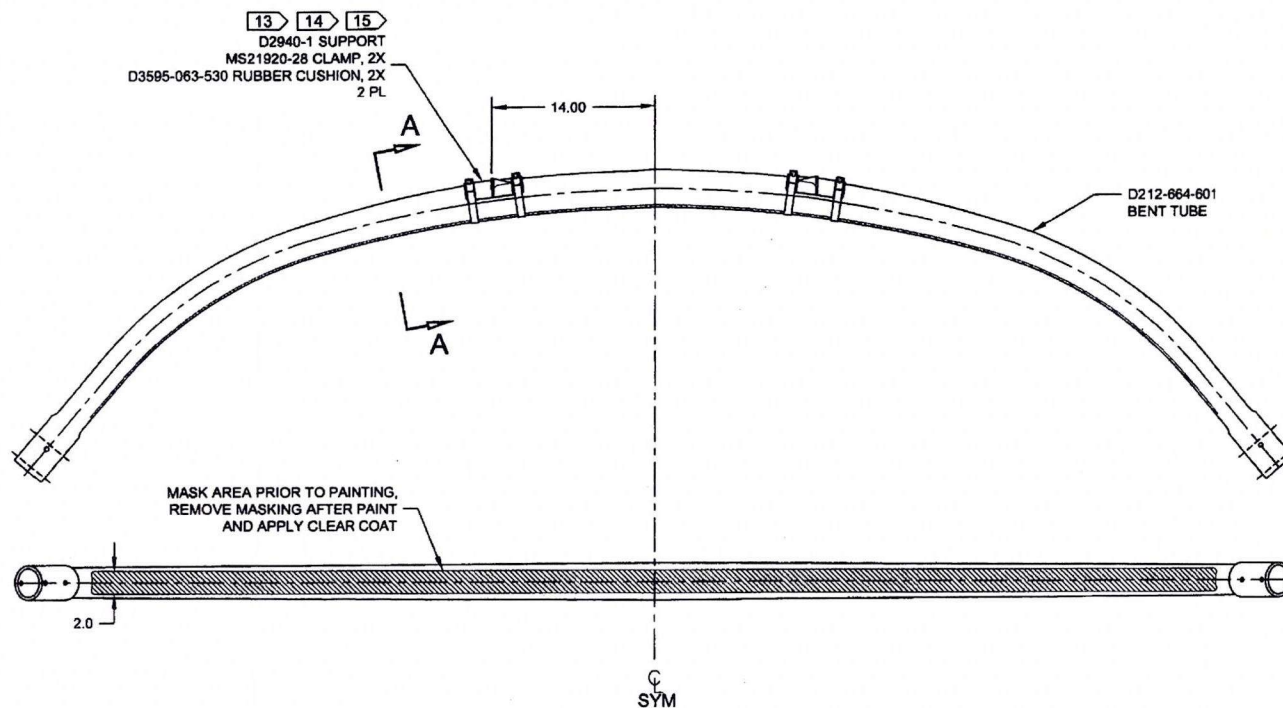
SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 195551 MJS
19-05-27

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2014-05-26
MP

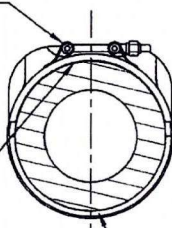
E	D5018-1 WAS D2940-1 (-241B), PROSEAL WAS MAGNOBOND, NOTE 2: ADD INSPECTION WINDOW, NOTE 11: ALLOW 7.2% CRUSH, NOTE 15: ADD 72HR CURE AND RETORQUE FOR PROSEAL, ADD SHEET 3, CLAMPS REVERSED TO PREVENT CHAFING (ZN B7-2, B7-3), BEND HEIGHT TOL. NOW 0.25 WAS 0.13 (C1-4), INCORP DEO D-1/2	CP	14.04.01
D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -241B (ZN D4-2, B4-2); REMOVED REF & ADD TOLERANCES (ZN D8-3 & C4-3, C6-3 & A8-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	CP	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	14.04.01		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D212-664-241	REV. E SHEET 1 OF 5
TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE NTS
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MS21920-28
CLAMP, REF
14 15

APPLY PROSEAL
BETWEEN D2940-1 AND
CROSSTUBE



D2940-1
SUPPORT,
REF

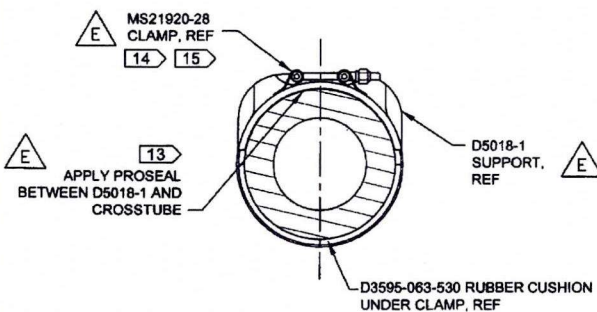
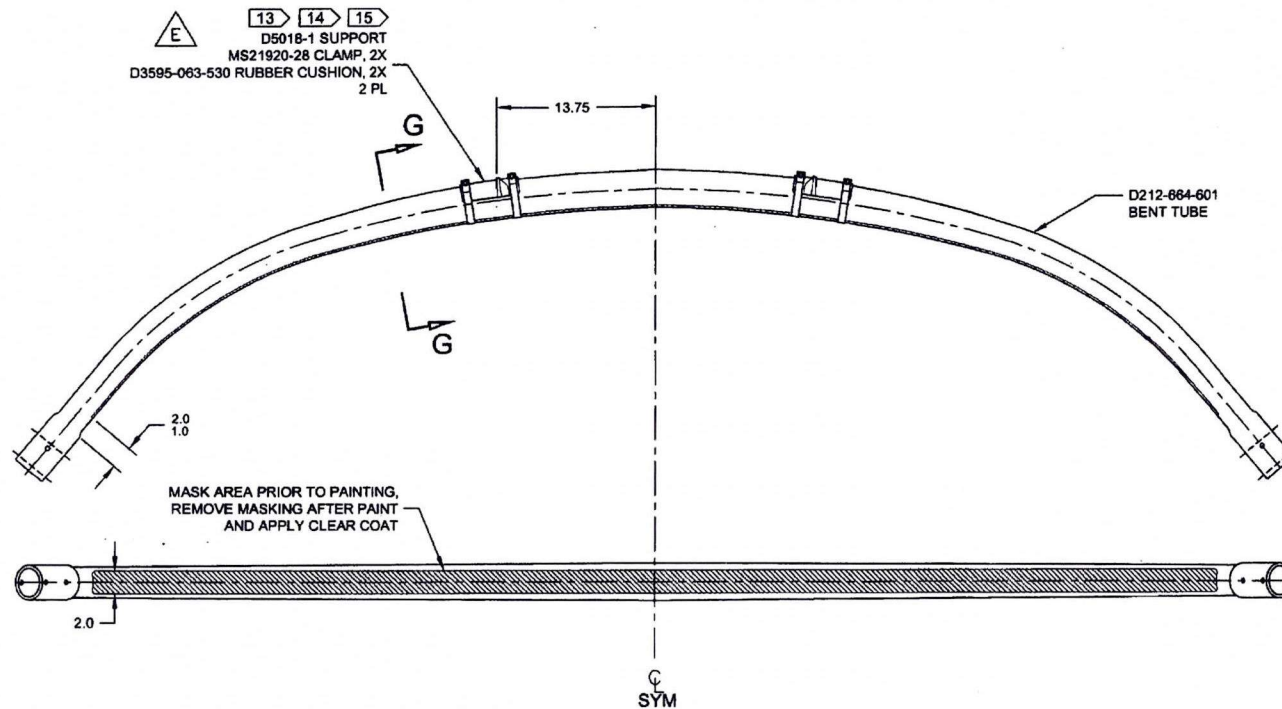
D3595-063-530 RUBBER CUSHION
UNDER CLAMP, REF

SECTION A-A
SCALE 4X

D212-664-241
ASSEMBLY DETAIL

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2014-05-26

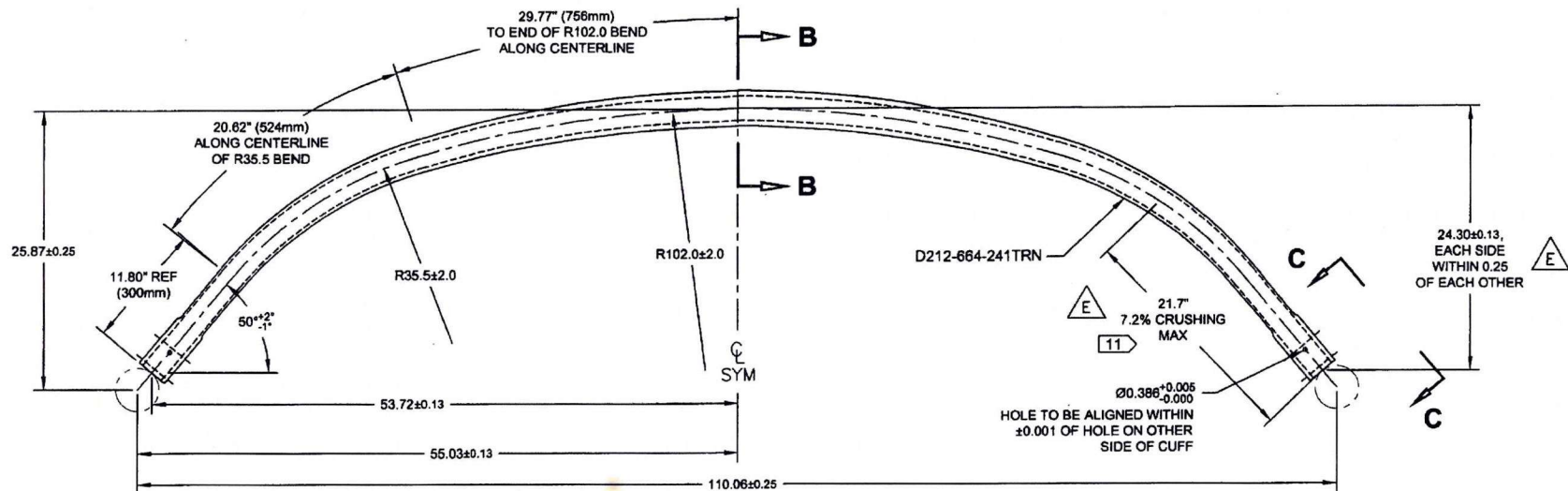
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D212-664-241	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
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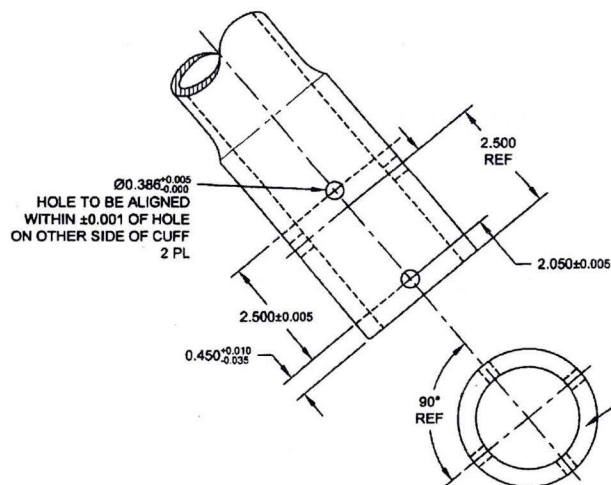
**D212-664-241B
ASSEMBLY DETAIL**

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2014-05-26

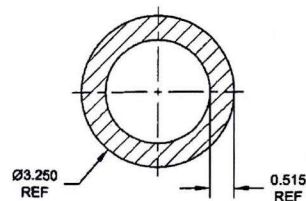
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CHECKED	92	DRAWING NO.	REV. E
MFG. APPR.		D212-664-241	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
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D212-664-601 11
BENDING AND DRILLING DETAIL



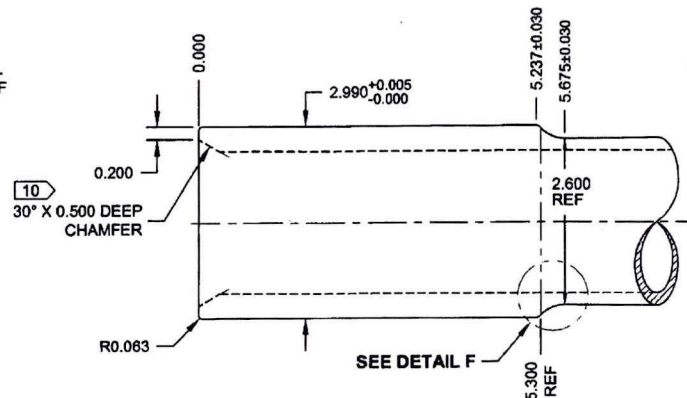
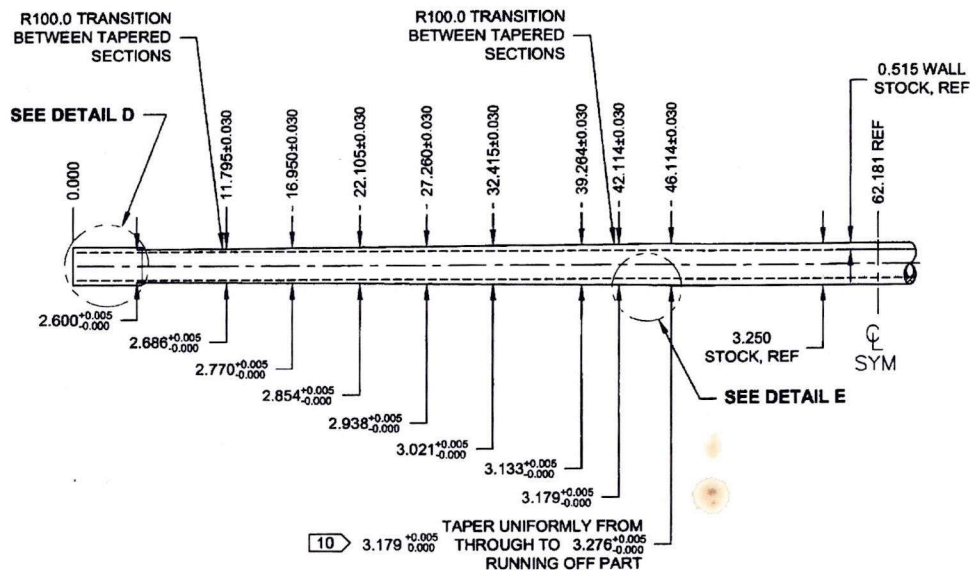
VIEW C-C: CUFF DETAIL
 SCALE 3X



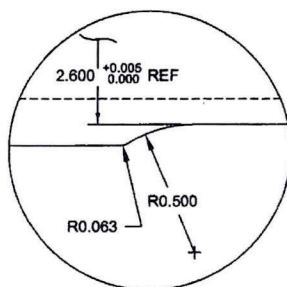
SECTION B-B
 SCALE 4X

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 2014-05-26
MD

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CHECKED	<i>DW</i>	DRAWING NO. D212-664-241	REV. E
MFG. APPR.	<i>JP</i>		SHEET 4 OF 5
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
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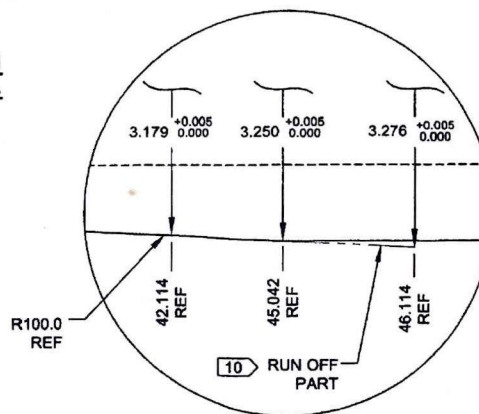


DETAIL D:
 CROSSTUBE CUFF
 SCALE 5X



DETAIL F:
 CUFF TRANSITION
 SCALE 10X

D212-664-241TRN
 TURNING DETAIL



DETAIL E:
 TAPER RUN-OFF
 NOT TO SCALE

RELEASE
 2014-05-26

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D212-664-241	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					